

Date: Tuesday, 7/17/2007 1:59:23 PM
 User: Kim Johnston

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 33579
 Estimate Number : 12576
 P.O. Number : N/A
 This Issue : 7/17/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 32719
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-11-09 JLM

Drawing Name : STEP WELDMENT
 Part Number : D3562041
 Drawing Number : D3562 UNDER REVIEW O/C P
 Project Number : N/A
 Drawing Revision : A/C
 Material : N/A
 Due Date : 8/3/2007 Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion B32858
		Check Material for any Dents or Defects a.m 07.07.24
2.0	D2734	206 Step Endplate
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s) Pick: Qty Part Number Description Batch: 2 D2734 End Cap B33861
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
 1-Cut D2622 extrusion as per Dwg D3562 a.m 07.07.24 \$5
 2-Deburr and bevel ends for welding a.m 07.07.24 \$5
 3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.
 A/R Aluminum Rod _____
 4-Grind end cap welds flush as per Dwg D3562

to be
done yet
③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 1:59:23 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33579

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sp 07/08/2007 6041

5.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 07.07.25

45

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Sp 07.10.01 x(1)

8.0 D3560041

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT 334964(3)334474(2) a.m 07.10.03

PTO →

9.0 D3560043

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

Batch: 334964

a.m 07.10.03

(5)

10.0 MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 216.0000 Each(s)

Blind Rivet

batch: M105125

a.m 07.10.04

(5)

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562.

Touch-up rivet holes with alodine as per dwg d3562

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnabond of the step

a.m 07.10.04

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.07.17	18.S	Qty (2) DZ808 SPACER B/N <u>B32752</u> PRESS FIT AFTER POWDER COAT. TEMPORARILY SECURE w/ MASKING TAPE UNTIL ASSEMBLY INTO 0412-630-0331-034 STEP. PERMANENT CHG PER DWG	MF	07-10-17	5	UP 07.07.17 PC QSI 042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2007 1:59:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33579

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Magnabond 6398

Batch: M104677

a.m 07.10.09

6

12.0

QC5

INSPECT WORK TO CURRENT STEP



5 07/10/09 X5041

Comment: INSPECT WORK TO CURRENT STEP

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M103794

10.10.09 5

2-Grind end cap welds flush as per Dwg D3562

a.m 07.10.10

6

14.0 QC9

VISUAL WELDING INSPECTION

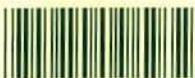


Comment: VISUAL WELDING INSPECTION

PD 07.10.10 5

15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/10/10 X5041

16.0 POWDER COATING

POWDER COATING



M105068

Ex PTO 7

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-f 07/10/11

17.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M105694

Fd 07/10/12

5

18.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-10-16

18.5 SEE W/D CHG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/11	# 16	ADD to w/o 45 Remount chase to touch up ends with Alodine 45 per QSF 005	43	07.10.11	3		EN 07/10/11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

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Drawing Name: STEP WELDMENT

Job Number: 33579

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

CPP 33576 C 7/10/18(4)

20.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

3 07/10/18(4)

Job Completion



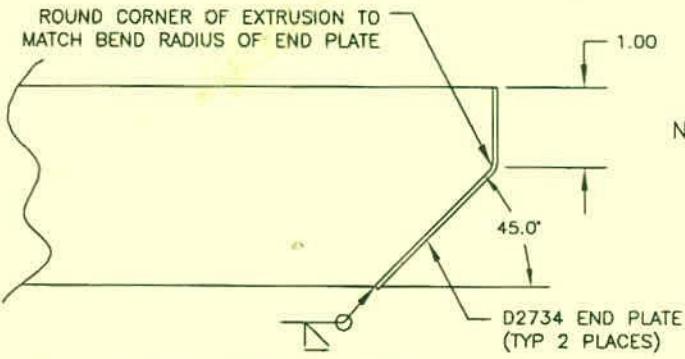
U 07/10/18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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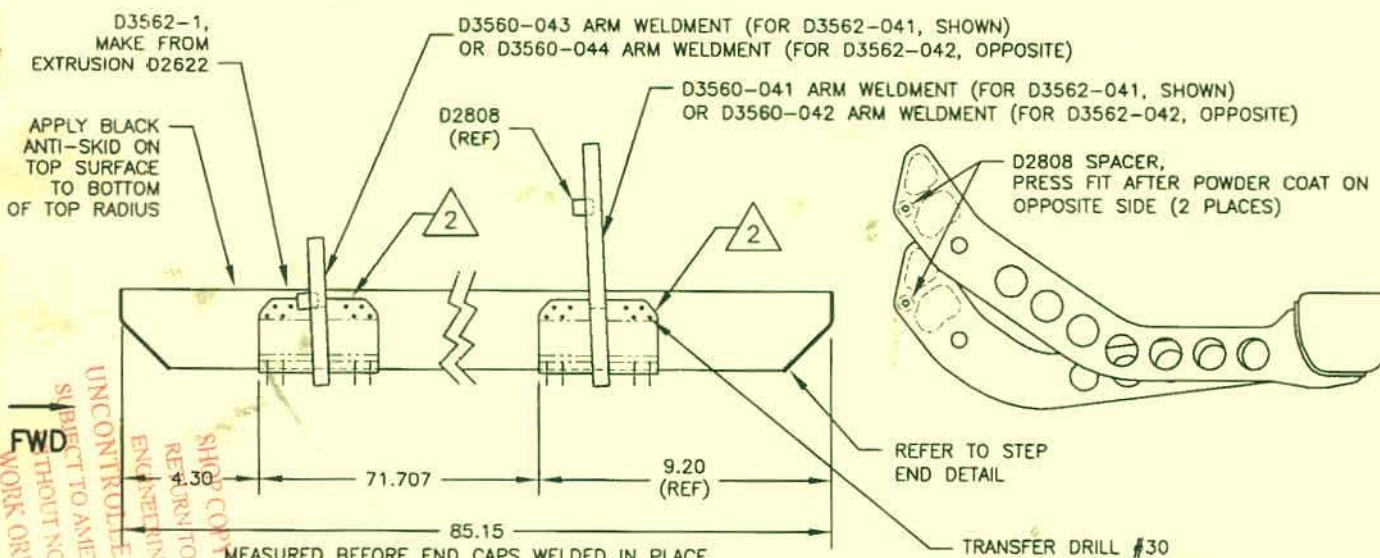
NOTE: Date & initial all entries

DART**RELEASED**
07.06.2014

NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004

TYPICAL STEP END DETAIL

NOT TO SCALE

**D3562-041 LH STEP ASSEMBLY (SHOWN)****D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D3562
DATE		SHEET 1 OF 1
07.06.19		NTS
A	06.09.26	TITLE
B	07.01.15	STEP ASSEMBLY
C	07.06.19	SCALE
		REV. C
		NTS

